



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM652V3002102-5
Job Sheet 195655



Part No: RBEM652V3002102-5

Job Qty: 1 pcs

Part Name: Guide Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/29/19

Job Tracking No:

Due Date: 6/26/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBEM652V3002102 Rev A IPP Rev. A 19.05.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	1 pcs	6/26/19	6/26/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	JUN 26 2019
110	Packaging 2-1 - Receive - B4B	1 pcs	6/26/19	6/26/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B	JUN 26 2019



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194238



Part: RBEM652V3002102 - 5

Job No: 195655

Serial No/Batch: S194238

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 06/26/19

Plex 5/29/19 10:35 AM dart.Lussier.Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	1 pcs	6/26/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
130 Packaging 3-1 - Stock - B4B	1 pcs	6/26/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	6/26/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	

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MC

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TBD

Part Op 100 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O 43577 -Manufacture RBEM652V3002102-5 as
 Descriptions: per DWG. -Certificate of Conformity is required
 110 - Certificate of Conformity is required
 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

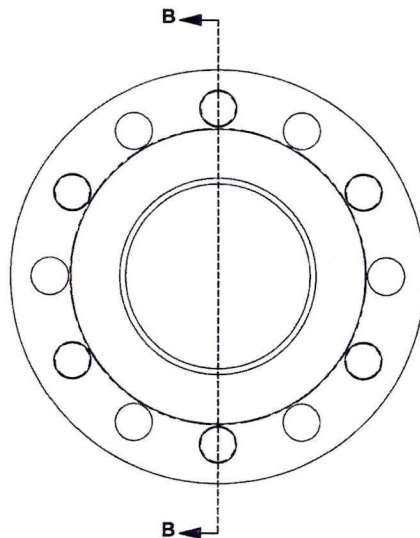
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM652V3002102-5P	Guide Assembly	1 (1 ea)	100-Purchasing	5194232

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEM652V3002102-5P	1	0	0
Part Specifications				
Specifications could not be found.				

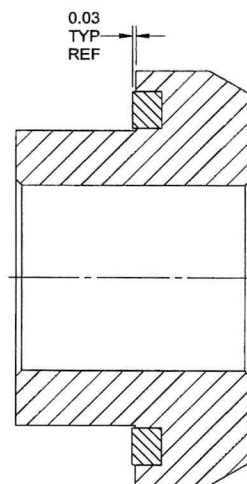
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ITEM #	QTY	PART #	PART TITLE
-6	1	RBEM652V3002102-6	BASE
20	6	McMaster#5862K178 OR EQUIV.	NICKEL PLATE NEODYMIUM MAGNET THROUGH THK. 5/16" OD. X 1/4" THK. MAX. PULL 6 LBS

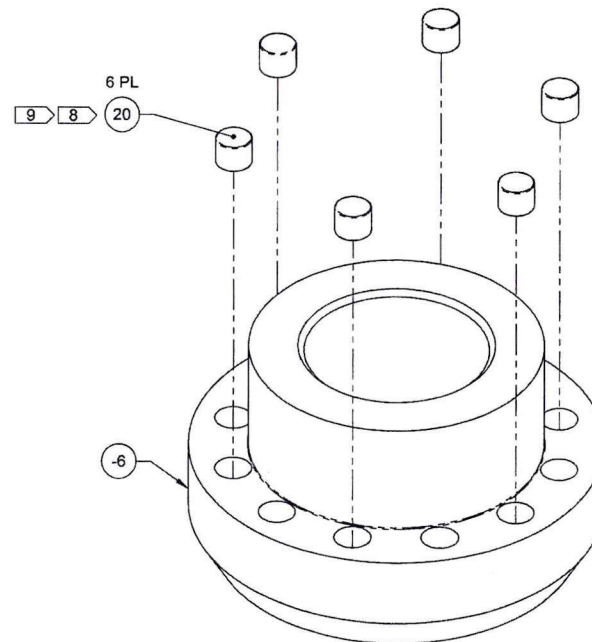


RBEM652V3002102-5 GUIDE ASSEMBLY

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SECTION B-B



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -6 AND ITEM 20, AND REMOVE EXCESS

9) NORTH POLE OF ITEM 20 MUST BE FACING UP AS SHOWN

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 6 OF 17
APPROVED	W	TITLE	SCALE
		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
DATE	2019-05-24	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043577



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043577

PO Date: 5/29/19

Due Date: 6/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	195655	RBEM652V3002102-5P			Guide Assembly REV A	Firmed	-	6/26/19	1 Ea	0 Ea	1 Ea	\$676.42/Ea	\$676.42
						1 x	JUN 26 2019						
2	195656	RBEM652V3002102-7P			Exchange Assembly REV A	Firmed	-	6/26/19	1 Ea	0 Ea	1 Ea	\$3,468.58/Ea	\$3,468.58
						1 x	JUN 26 2019						
Grand Total:												\$4,145.00	

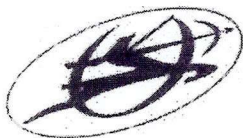
Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 600

Date: 6/25/2019
PO Ref: HB043577 ✓
Ship via: Fedex Priority

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Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

1 ✓

1 ✓

Item

GUIDE ASSEMBLY
EXCHANGE ASSEMBLY

Part No.

✓ RBEM652V3002102-5 REV A
✓ RBEM652V3002102-7 REV A

RECEIVED

JUN 26 2019

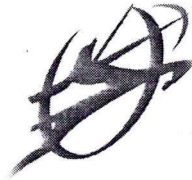
DART AEROSPACE LTD.

Received by:

Packaged by: J.M.L.

Checked by: ADP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043577 ✓

Dated: 6/25/2019

Our Order / Job No: HB043577-1AWT

Order Qty: 1 ✓

Part Name: GUIDE ASSEMBLY

Part Number RBEM652V3002102-5 ✓

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Lot Size: N/A Ship Date: 6/25/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBEM652V3002102-5

Rev: A

Material Size and Type: -6/ 6061-T6 ALUM.

Material Specifications: ALUM: B209

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MIL-8625F TYPE 2 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 6/25/19

Signed: Hamid M. Fakhri

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com